

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022233**Date Inspected:** 28-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on Bike Path Traveler Rails. ZPMC CWI Chen Shi Gang was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 5 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- 3016TR2-001-003

WPS-B-T-2231-ESAB

Welder- 059416

1G/FCAW/CJP

Weld- 3016TR1-002-002

WPS-B-T-2231-ESAB

Welder- 059418

1G/FCAW/CJP

Weld- 3012TR5-001-009

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

WPS-B-T-2231-ESAB

Welder- 203805

1G/FCAW/CJP

Weld- 3016TR3-001-006

WPS-B-T-2231-ESAB

Welder- 062265

1G/FCAW/CJP

The following digital picture illustrates welding Traveler Rail 3012TR5 and 3016TR3.

Bay 1

This QA inspector observed ZPMC in process of SMAW welding weld repair on Re-Built traveler rail 20TR2 assembly. ZPMC CWI Tian Lei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20488

Weld- 20TR2-038-011

WPS-345-SMAW-1G(1F)-Repair

Welder- 048659

1G/SMAW/CJP

Bay 8

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of grinding interior welds/ surfaces on Saddle Housing sub-assembly SA7047 and machining plate edge angle on X4021A, X4014A, 7066A OBG sub-components per GGL-MQ-2215.dwg

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding on Bike Path Assemblies. ZPMC QC inspector Sun Zi Wang was present at this time of this observation and informed this QA inspector of the work that is in process and identified Fu Guo Gang as the CWI. It was stated that ZPMC had 5 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- BK008A1-001-005

WPS-B-T-2132-ESAB

Welder- 057266

2F/FCAW

Weld- BK014A6-001-029, 030

WPS-B-T-2132-ESAB

Welder- 053869

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

2F/FCAW

Weld- BK014A6-001-043, 162

WPS-B-P-2113

Welder- 056364

3F/SMAW

Weld- BK014A8-001-013-014

WPS-B-P-2113

Welder- 050038

3F/SMAW

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
